

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022784**Date Inspected:** 01-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

**Trial Assembly Yard**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08708 from ZPMC for TA Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG 13AE. The weld designations reviewed are as follows.

SEG3007G-048, 049, 054~056, 058~060, 062, 063, 065~067, 069~071, 073~075, 077~079, 081~083,

085~087, 089~091, 093~095, 120~122, 124, 129~132, 201

SA3012-229~246, 247~259, 171~202, 211, 217, 218, 222, 270~274

SEG3007AV-070, 071, 072

**Bay 11**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08707 from ZPMC for Bay 11. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as Tower Boom Support. The weld designations

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reviewed are as follows.

ESD1-TBSA7-3-023, 024

NSD1-TBSA7-3-023, 024

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Anchor Plate Deck

PCMK: SEG3020AQ

Weld Number: 025

Welder: 066398

WPS-B-P-2211-TC-U4b-FCM-1

Component: Anchor Plate Deck

PCMK: SEG3020AQ

Weld Number: 025

Welder: 066002

WPS-B-P-2211-TC-U4b-FCM-1

Component: Anchor Plate Deck

PCMK: SEG3020AQ

Weld Number: 025

Welder: 066443

WPS-B-P-2211-TC-U4b-FCM-1

Component: Vertical Shear Plate

PCMK: SEG3020BB

Weld Number: 038

Welder: 067829

WPS-B-P-2214-TC-U4b-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Combs,Dennis	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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